

Work Order ID 96193

January-24-13 7:59:29 AM

96193

~~U/R~~

Page 1

Item ID: D3705-1

Accept

N900040100

Setup Start

NS1

Revision ID: U/R 62 9/13/12/5

Item Name: MAIN PANEL

Stop

NS2

Start Date: 2/04/13 Start Qty: 500

5

Cust Item ID:

Required Date: 2/04/13 Req'd Qty: 500

5

Customer:

Reference:

Approvals:

Process Plan: MLC

Date: 13-01-25

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3705

E

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3705

Dwg Rev: E

Prog Rev: E

grain direction -

2- Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

9/8 01 Jm 13-1-29

PTO →

9/8 01 Jm 13-1-29

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Aw Date: 13/02/09QA Closed: OK Date: 13/02/09

Work Order: <u>96193</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3705-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-2296</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator	13-1-29	100	1x	Sheet moved when cut out flipped up, hitting jet nozzle. keep closer eye on mat'l when cutting	DAS 12 2-88 13/1/31	Scrap + destroy no result.	JM 13-1-29	DAS 15 2-88 13-1-29	S 13/2/5
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input checked="" type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 96193

96193

Page 2

January-24-13 7:59:29 AM

Item ID: D3705-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: MAIN PANEL
Start Date: 2/04/13 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 2/04/13 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8			
130 *130* Small Fab Small Fab	Small Fab Memo 1-COUNTER SINK AS PER DWG 2- BEND AS PER DWG D3705	0.00 0.00				6-2			PTO SB 13/04/30
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				6			

NCR: ☒ Yes ☐ No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AK Date: 13/02/07QA Closed: CK Date: 13/02/07

Work Order: <u>B 96193</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3705-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-7295</u>		Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material	<u>13/01/07</u>	<u>120</u>	<u>7</u>	2 piece scrap 1 piece crack + second out of Tolerance Z-L setup wrong	<u>AK</u> <u>13/1/31</u>	Scrap & destroy, no replace <u>60.09</u> <u>121.38</u>	<u>AK</u> <u>13/01/30</u>	<u>AK</u> <u>13-129</u>	<u>S</u> <u>13/2/15</u>
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input checked="" type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input checked="" type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection 'ncomplete
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input checked="" type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input checked="" type="checkbox"/> Other
		<u>set up wrong. / need to use</u>
		<u>1st piece Better Starting</u>
		<u>Bending</u>

Work Order ID 96193

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Page 3

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Item ID: D3705-1

Accept

N900040100

Setup Start *NS1*

Revision ID: U/R

Stop *NS2*

Item Name: MAIN PANEL

Start Date: 2/04/13 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 2/04/13 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>W/A 001</i>	0.00							
150									
Packaging	Memo	0.00				<i>6</i>	<i>2</i>	<i>13-1-30</i>	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							<i>13/1/31</i>
Quality Control									

13-01-31

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

January-24-13 7:59:29 AM

Page 1

Work Order ID: 96193

Parent Item: D3705-1

Parent Item Name: MAIN PANEL

Start Date: 2/04/13

Required Date: 2/04/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 08-01-30 new issue EC verified by:DD
 IPP Rev:B 09-01-09 rev.C as per dwg DD verified by:EC
 IPP Rev:C as per dwg RevD DD 10.04.27 verified by:EC IPP REV:D 13.01.15 AS PER DWG
 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	292.0686	2.16	11.368421			
6061-T6 .080 Sheet											1.2	Jm 13-1-29	
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>						
				MAT021	292.068632								
				117285	0.248632								
				119766	39.82								
				120096	168.8								
				123279	83.2								
										123279			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
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		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

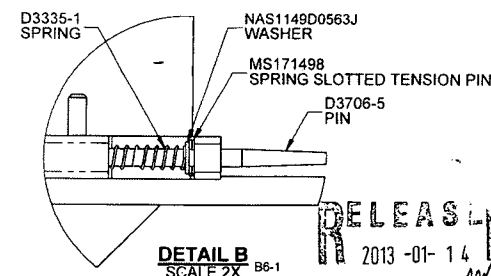
DART AEROSPACE LTD		Work Order: 9693
Description: Main Panel		Part Number: DB705-1
Inspection Dwg: DB705 Rev: E		Page 1 of 12

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098"	+0.004" -0.001"	0.098"	-		V	Jkma1
Ø0.201"	+0.005" -0.001"	0.202"	-		V	
Ø0.194"	+0.005" -0.001"	0.195"	-		V	
0.250"	+/-0.010"	0.253"	-		V	
0.500"	+/-0.010"	0.505"	-		V	
0.375"	+/-0.010"	0.378"	-		V	
0.573"	+/-0.010"	0.576"	-		V	
1.18"	+/-0.030"	1.18"	✓		V	
4.00"	+/-0.030"	4.013"	-		V	
4.375"	+/-0.010"	4.375"	-		V	
7.89"	+/-0.030"	7.89"	-		V	
8.31"	+/-0.030"	8.31"	-		V	Pratt & Whitney
8.625"	+/-0.010"	8.626"	-		V	
8.94"	+/-0.030"	8.94"	-		V	
9.125"	+/-0.010"	9.125"	-		V	
9.36"	+/-0.030"	9.36"	-		V	
12.50"	+/-0.030"	12.50"	-		T	Jkma6
12.927"	+/-0.010"	12.927"	-		T	
13.125"	+/-0.010"	13.125"	-		T	
13.50"	+/-0.030"	13.50"	-		T	
3.750"	+/-0.010"	3.754"	-		V	
7.849"	+/-0.030"	7.849"	-		V	
8.733"	+/-0.010"	8.733"	-		V	
12.750"	+/-0.010"	12.750"	-		T	
4.375"	+/-0.010"	4.375"	-		V	
10.06"	+/-0.030"	10.074"	-		V	
10.310"	+/-0.010"	10.310"	-		V	
10.86"	+/-0.030"	10.86"	-		V	
12.61"	+/-0.030"	12.61"	-		T	
13.164"	+/-0.010"	13.164"	-		T	
13.41"	+/-0.030"	13.41"	-		T	
14.348"	+/-0.010"	14.348"	-		T	

Measured by: Jm	Audited by: DAS	Preliminary Approval:
Date: 13-1-29	Date: 13-1-29	Date:

ITEM	QTY	P/N	DESCRIPTION
	X	D3705-041	INSTRUMENT PANEL ASS'Y
1	1	D3335-1	SPRING
2	1	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-5	ACCESS PANEL
4	1	D3706-041	LOCK BRACKET ASSEMBLY
5	1	D3706-5	PIN
6	2	D3707-3	MOUNTING LUG
7	2	AN3-3A	BOLT
8	4	AN526C1032R6	SCREW
9	1	NAS1149D0563J	WASHER (OR AN960JD516)
10	28	CR1122-3-02.5	RIVET
11	1	MS171498	SPRING SLOTTED TENSION PIN
12	14	MS21075L3	NUT PLATE
13	4	MS24693C272	SCREW
14	2	NAS1149D0332J	WASHER (OR AN960JD10L)



E	REVISED D3705-1/3 (NOW 0.75 TALLER - AFFECTS -1F/-3F); D3706-1/3 NOW D3706-041 AND BOLTED; ADD AN3-3A BOLT; NAS1149D0332J WASHER; D3706-041; 9.88 WAS 9.13 (Z/Ns D1-3, B3-3, C7-4); 6.000 WAS 7.150 (Z/N C4-6); 3.20 lbs WAS 3.00 lbs. REASON: CIR12-4/PAR12-188.	MB	12.11.30
D	ITEM 14 WAS AN960JD416 (Z/N D3-1 AND C1-1). REASON: NCR#10-017.	MB	10.04.15
C	ADDED D3705-7/9-11 (SHEET 6); REMOVED MS35589-156 GROMMET; 9.31 AND 12.66 WERE 9.36 AND 12.61 (Z/N B6-3); Ø 1.90 WAS 1.50 (Z/N D5-4); ADDED Ø 0.204 HOLE (Z/N D6-4); CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS.	MB	08.11.20
B	ADDED MS35489-156; QTY. 14 MS21075L3 WAS QTY. 8; QTY. 28 MS20426AD3-3 WAS QTY. 16; MS171498 WAS TP-2; AN526C1032R6 WAS MS27059-1-09 & AN960JD10L (Z/N D3-1); REDESIGNED D3705-1F FLAT PATTERN (Z/N B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.30		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3705 REV. E SHEET 1 OF 6 TITLE INSTRUMENT PANEL ASS'Y SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

D3705-041 INSTRUMENT PANEL ASS'Y

D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: 3.20 lbs

MS21075L3 NUTPLATE
REF

AN526C1032R6 SCREW
4 PL

D3705-5
ACCESS PANEL

D3705-043 INSTRUMENT
PANEL WELDMENT

B2-1

D3706-041 LOCK
BRACKET ASSEMBLY

D3707-3 MOUNTING LUG
2 PL

MS21075L3 NUTPLATE, 1X
CR1122-3-02.5 RIVET, 2X
14 PL

MS24693-C272 SCREW
4 PL

D3707-3 MOUNTING LUG
REF

SECTION A-A
SCALE 2X

AN3-3A BOLT
NAS1149D0332J WASHER
2 PL

SECTION G-G C4-1

UNCONF

SUBJECT

W/

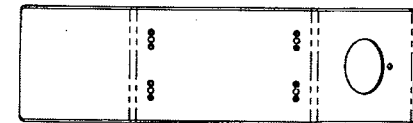
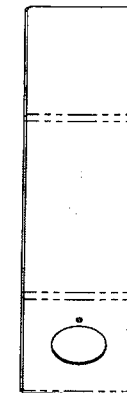
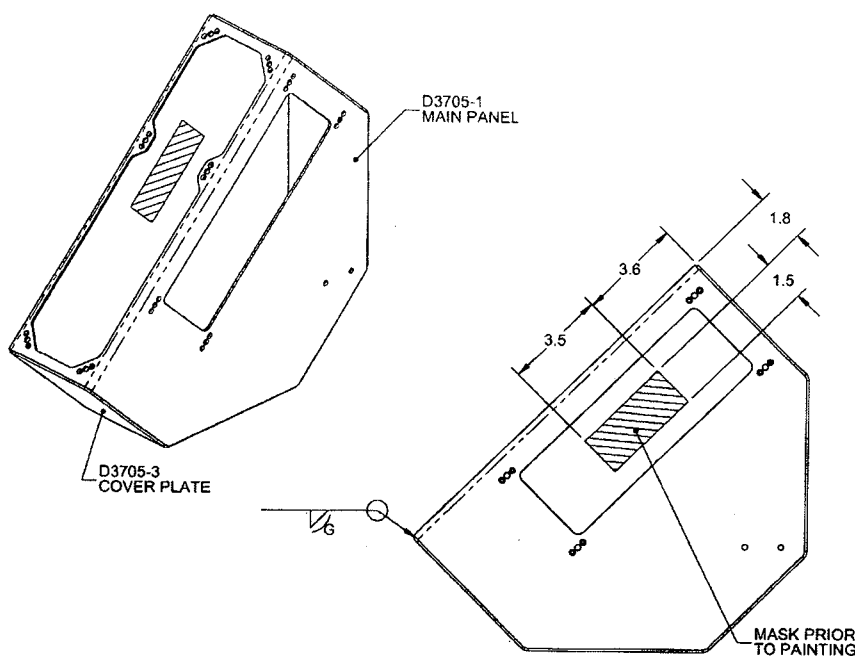
W/

NO. 96193 MLC

13-01-25

96193

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE



D3705-043 INSTRUMENT PANEL WELDMENT

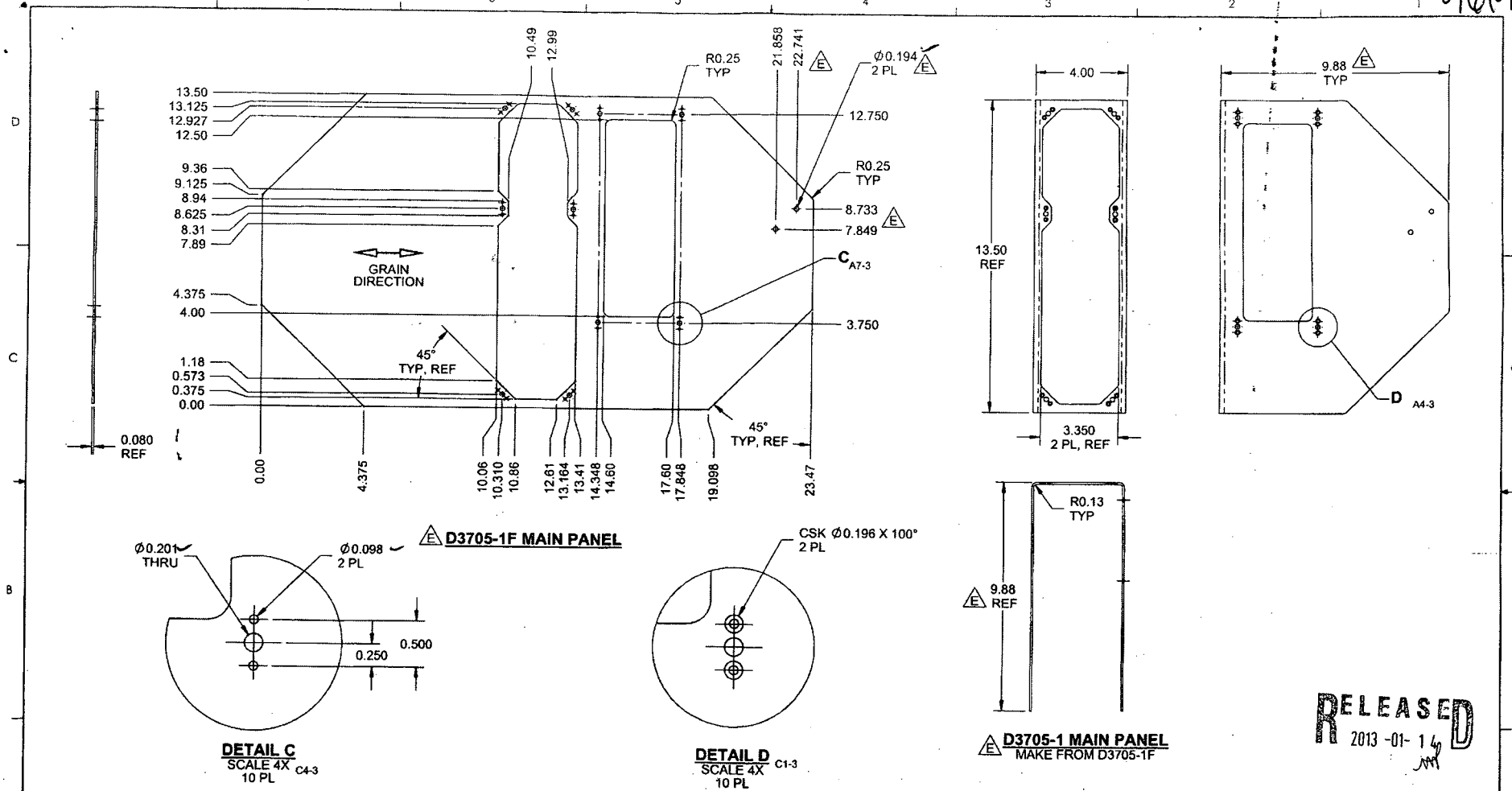
RELEASED
2013-01-14

D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.20 lbs
- 8) WELDING: PER DART QSI 004

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DRAWN			SHEET 2 OF 6
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	12.11.30		

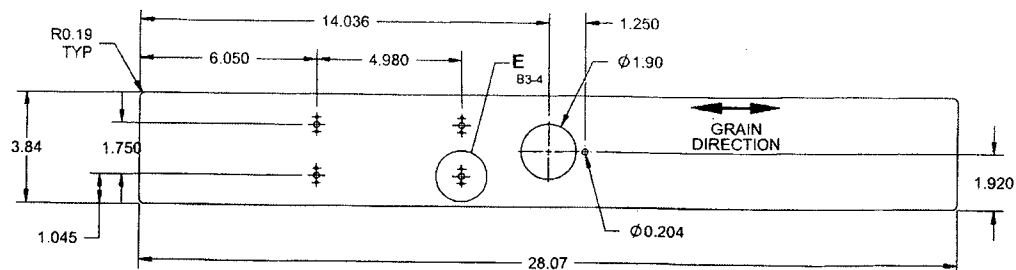
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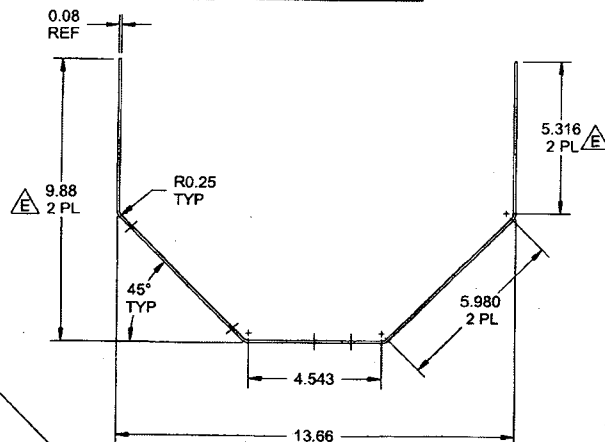
RELEASED
2013-01-14

- D3705-1/1F NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.65 lbs

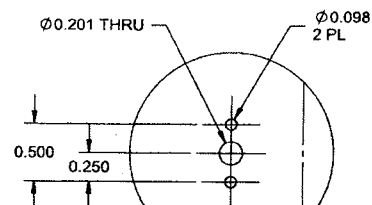
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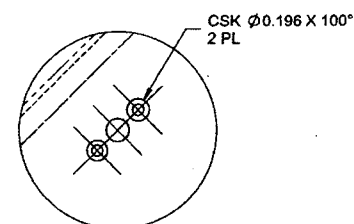
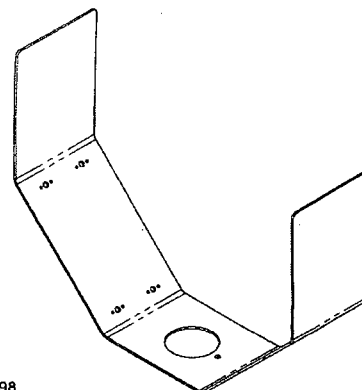
D3705-3F COVER PLATE FLAT PATTERN



D3705-3 COVER PLATE (MAKE FROM D3705-3F)



DETAIL E SCALE 4X 4 PL



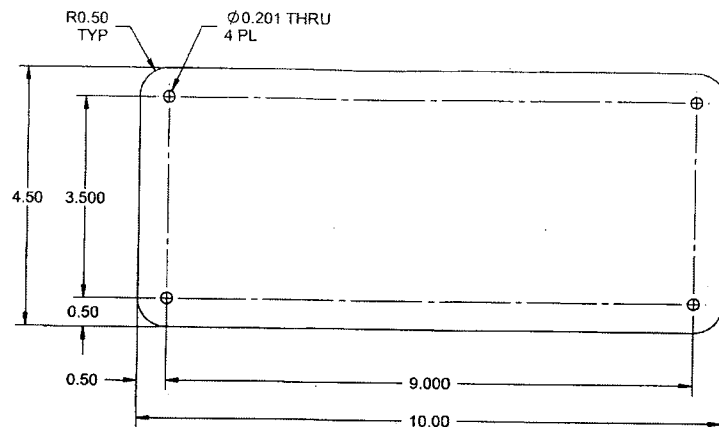
DETAIL F SCALE 4X 4 PL

RELEASE
2013-01-14

D3705-3/3F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs

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D3705-5 ACCESS PANEL

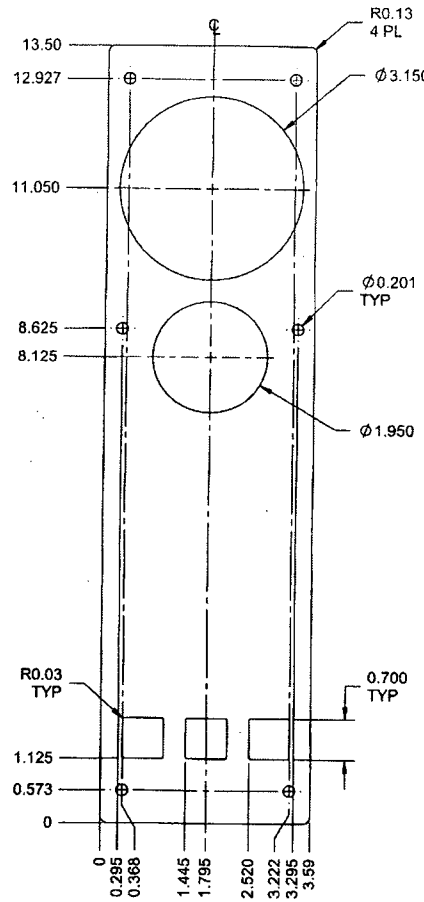
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D3705-5 NOTES:

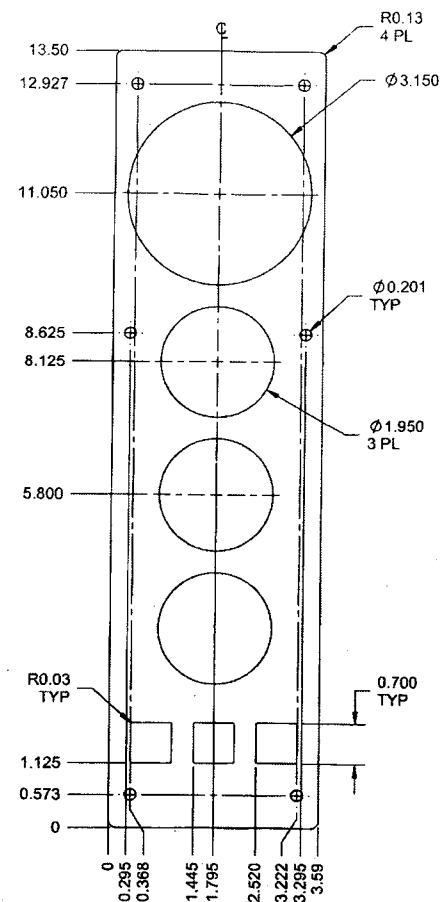
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 8) WEIGHT: 0.17 lbs

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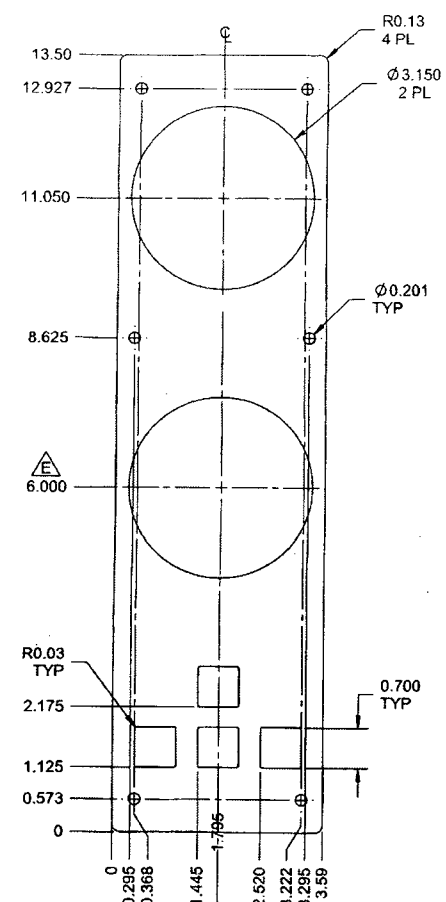
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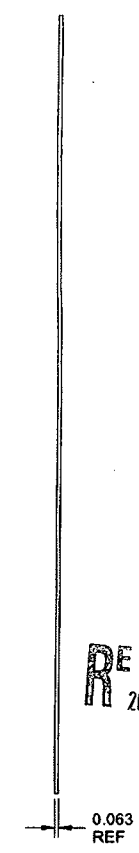
D3705-7 FACE PLATE



D3705-9 FACE PLATE



D3705-11 FACE PLATE



SIDE VIEW
TYP

- D3705-7/-9/-11 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
 - 7) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

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